

Garant**DNGA 150612, BU7220, Cutting edge version: G****Order data**

Order number	255451 G
GTIN	4045197895400
Item class	21H

Description**Version:**

Fitted with 2 cutters.

Description:

New type of CBN with a balanced combination wear-resistance and tensile strength for general-purpose use in hardened steel up to 67 HRC in combination with a special constitution. For use both in continuous cutting and also in slightly interrupted and heavily interrupted cutting.

Grade: BU7220

Cutting edge version: G

Cutting depth a_p : 0.05 - 0.2 mm

Feed f : 0.05 - 0.15 mm/rev.

Cutting speed v_c main application: 90 - 140 m/min

Technical description

Cutting depth a_p	0.05 - 0.2 mm
Cutting edge version	G
Cutting conditions	continuous

Cutting conditions	heavily interrupted
Cutting conditions	slightly interrupted
Grade	BU7220
Tool material	CBN
Corner radius	1.2 mm
Feed f	0.05 - 0.15 mm/rev.
Cutting speed v_c main application	90 - 140 m/min
Finishing/roughing assignment	Finishing
ISO code indexable insert	DNGA 150612
Number of changes/inserts	2
Product name attribute	BU7220
Type of product	Indexable insert for turning

User data

	Suitability	V_c	ISO code
Steel < 55 HRC	suitable		
Steel < 60 HRC	suitable		
Steel < 67 HRC	suitable		
continuous	suitable		
irregular	suitable		
interrupted	suitable		
dry	suitable		